

Friday, March 13, 2015 12:51:46 PM

130505

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Step Spacer

Stop *NS2*

Start Date: 3/13/2015 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 3/13/2015 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-03-13

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

SPC (Y/N):

Date:

Stop *NR2*

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130505

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Item ID: D3720-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Spacer
Start Date: 3/13/2015 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 3/13/2015 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

15/3/30

Picklist Print

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Work Order ID: 130505

130505

Parent Item: D3720-1

D3720-1

Parent Item Name: Step Spacer

Start Date: 3/13/2015

Required Date: 3/13/2015

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev :A New Issue 08-01-11 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased		No		100	sf	110.4395	0.085	2			
M6061T6S 125									**				
6061-T6 .125 Sheet													

DL15/03/22

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	110.43945	
m127454	1.75	
m13074	18.68945	
m131352	90	

2.5

DART AEROSPACE LTD		Work Order: 130505
Description: Step Spacer		Part Number: D3720-1
Inspection Dwg: D3720	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

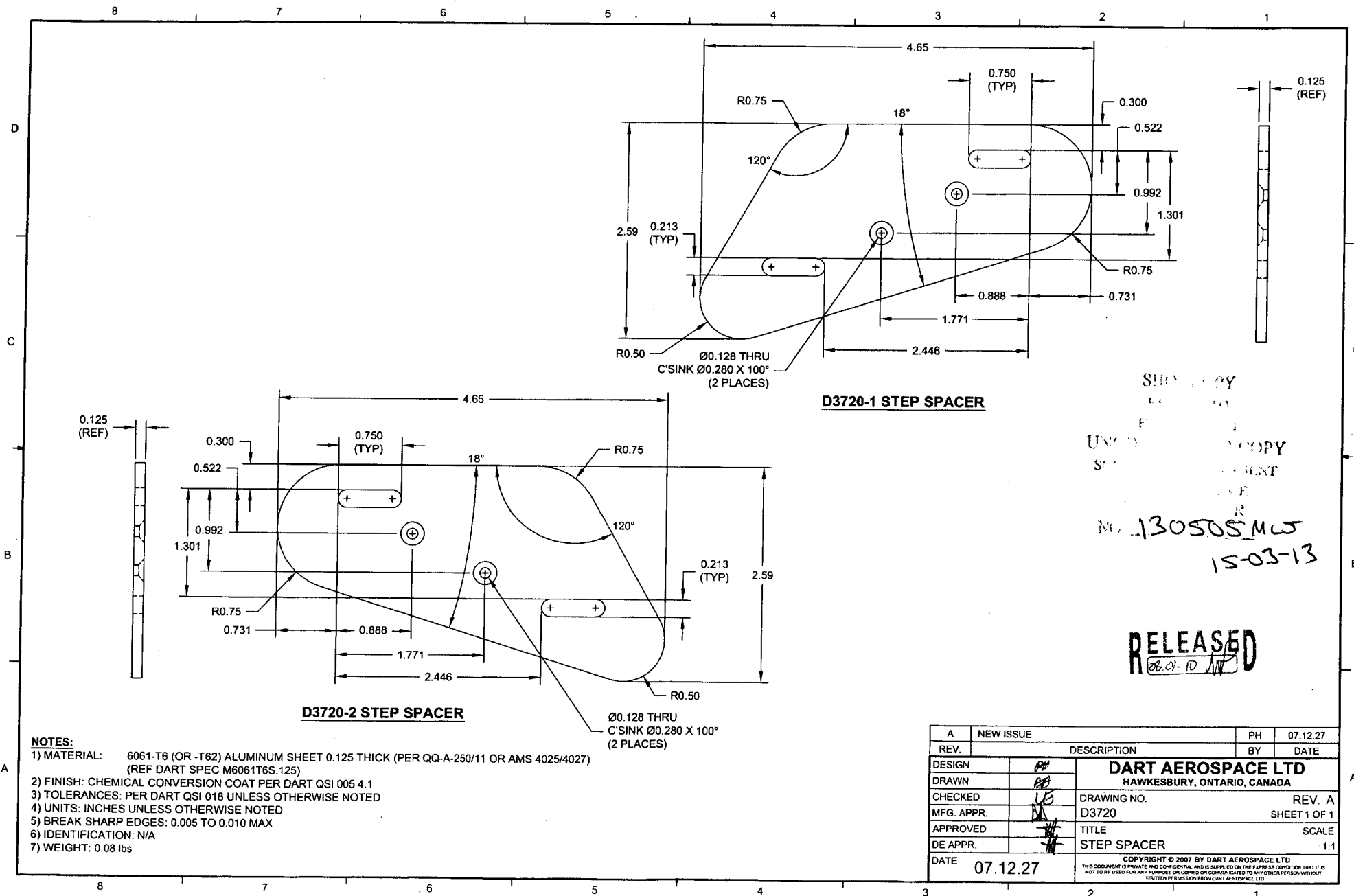
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	Ø.130	✓		V=Da-0.2	
4.65	+/-0.030	4.652	✓			
2.59	+/-0.030	2.589	✓			
0.750	+/-0.010	.749	✓			
0.300	+/-0.010	.301	✓			
0.522	+/-0.010	.520	✓			
0.992	+/-0.010	.990	✓			
1.301	+/-0.010	1.301	✓			
0.731	+/-0.010	.730	✓			
0.888	+/-0.010	.888	✓			
1.771	+/-0.010	1.771	✓			
2.446	+/-0.010	2.445	✓			
0.213	+/-0.010	.212	✓			

Measured by: DR	Audited by: DAS 38	Prototype Approval: N/A
Date: 15/03/22	Date: 9-89	Date: N/A

MAR 23 2015

Rev	Date	Change	Revised by	Approved
A	08.02.29	New Issue	KJ/DD	DA



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NO. 130505 MLW
15-03-13

RELEASED
86.01.10

REV.	DESCRIPTION	PH	DATE
A	NEW ISSUE		07.12.27
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.27		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D3720 SHEET 1 OF 1
TITLE SCALE
STEP SPACER 1:1

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